

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000625**Date Inspected:** 14-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	None	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	89 Mock-Up				

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 89 Meter Mock-Up Plate P213-1 to P1235-1 weld 63. Visually monitored Zenhau Port Machinery Company (ZPMC) Level II ultrasonic (UT) technicians during the scanning of the cover pass weld that joins these two plates. Level II UT technician E. Shuiqin using a Panametrics UT unit SN-061488510 calibrated with a 1.0 inch diameter 2.5MHz transducer for the lamination scanning of the plate areas either side and adjacent to the weld seam and a 70 degree 2.5MHz, 18mm x 18mm transducer SN1403 for the flaw detection scanning. Tests were performed from each face (Up side & Down side) of the plate with no relevant indications being noted. The UT shear wave testing utilizing the 45 degree 2.5Mhz, 18mm x18mm transducer SN3170 was performed by Level II UT technician Li Li Meng using a Panametrics UT unit SN051392712. One indication was observed during the scanning which was located on the plates edge in the center of the weld and visible to the eye. The indication was lightly ground then retested with no indications being observed. The ZPMC QA that was present during these tests was Li Xin Yong and QC Ma Qianli. There was no ZPMC or BV CWI present during the testing of either side of the plate.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Smith,David	Quality Assurance Inspector
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Reviewed By:	Cochran,Jim	QA Reviewer
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